

Work Order ID 131329

Thursday, April 02, 2015 11:53:42 AM

131329

Page 1

Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Damper Support Assembly, LH
 Start Date: 4/2/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/2/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-04-02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5134	A								
100		0.00							DAS
100									20
Bandsaw	Memo	0.00				4	Ø		9-89 15-04-19
Jeaspa Bandsaw	CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION*****								
110		0.00							DAS
110									44
HAAS 1	Memo	0.00				4	Ø		9-89 15/04/21
HAAS CNC vertical machine #1	Mill as per Dwg and folio FB342 DWG REV: <u>A</u> FOLIO REV: <u>A</u> DEBURR								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause		FAULT CATEGORY			
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Work Order ID 131329

Thursday, April 02, 2015 11:53:42 AM

131329

Page 4

Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Damper Support Assembly, LH
 Start Date: 4/2/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/2/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160									
Small Fab	Memo	0.00				4	FF		MAY 20 2015
Small Fab	install bushings as per dwg								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									DAG 38 9-89 MAY 20 2015
180	Identify as per dwg & Stock Location: <u>LG54</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									DAG 27 9-89 MAY 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Work Order ID 131329

Thursday, April 02, 2015 11:53:42 AM

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Item ID: D5134-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Damper Support Assembly, LH
Start Date: 4/2/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/2/2015 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ MAY 21 2015

MLJ MAY 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, April 02, 2015 11:53:46 AM

Page 1

Work Order ID: 131329

131329

Parent Item: D5134-041

D5134-041

Parent Item Name: Damper Support Assembly, LH

Start Date: 4/2/2015

Required Date: 4/2/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B3.000x04.00		Purchased	No				f	0.0000		2			

M7075T6B3 000x04 000

7075-T6 BAR 3.000' X 4.000" Grain along 3"

NAS77C6-021

Purchased

No

Each

38.0000

8

NAS77C6-021

BUSHING

**

1.750'

DAS
20
9-89

1504-19

**

FF MAY 20 2015

Location

ST260

130278
M131470

Loc Qty

38

38

Loc Code

8

1.750'

131999

DQA: _____ Date: _____



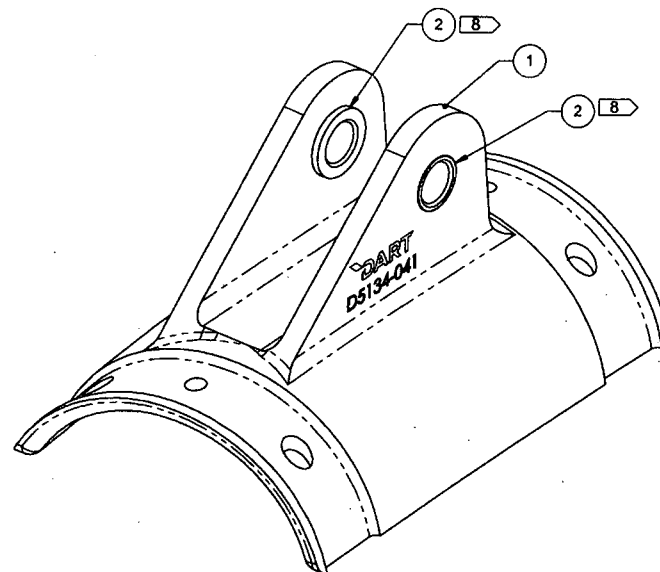
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Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5134-041	DAMPER BRACKET ASSY, LH
1	1	D5134-1	DAMPER SUPPORT, LH
2	2	NAS77C6-021	BUSHING



D5134-041 DAMPER SUPPORT ASSY, LH

131329 MWS
150402

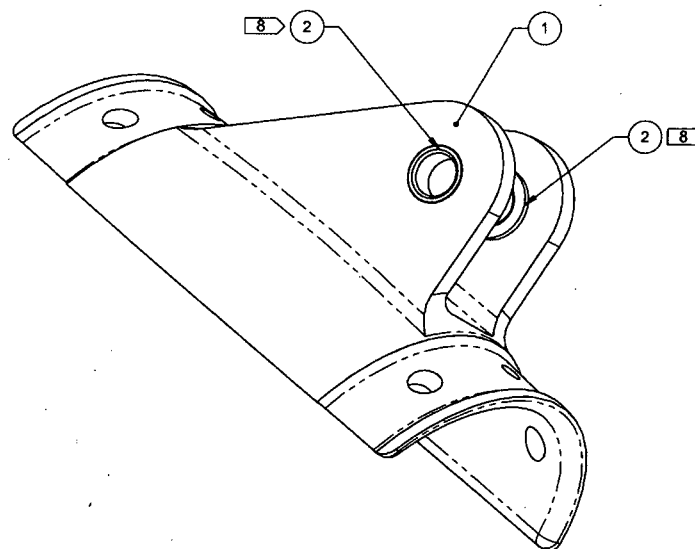
RELEASED
2014-10-08
MP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME AND PAINT WHITE PER DART QSI 005 4.2
MASK OFF INNER SURFACE OF BUSHING PRIOR TO APPLICATION OF PRIME/PAINT
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.41 lbs
 - 8) NAS77C6-021 BUSHINGS ARE PRESS FIT INTO D5134-1 DAMPER SUPPORT, IN ORIENTATION SHOWN

A		NEW ISSUE		AP	14.09.02
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 4	
DRAWN	AP				
CHECKED	ML	DRAWING NO.		REV. A	
MFG. APPR.	RQ	D5134		SCALE	
APPROVED	MP	TITLE		NTS	
DE APPR.	DS	DAMPER SUPPORT ASSY			
DATE		14.09.02		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5134-042	DAMPER SUPPORT ASSY, RH
1	1	D5134-2	DAMPER SUPPORT, RH
2	2	NAS77C6-021	BUSHING



D5134-042 DAMPER SUPPORT ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT WHITE PER DART QSI 005 4.2
MASK OFF INNER SURFACE OF BUSHING PRIOR TO APPLICATION OF PRIME/PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs
- 8) NAS77C6-021 BUSHINGS ARE PRESS FIT INTO D5134-2 DAMPER SUPPORT, IN ORIENTATION SHOWN

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5134	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
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RELEASED
2014-10-08
MD

9 Ø0.188 TOOLING HOLE
AS REQUIRED, 2 PL

9 Ø0.257 TOOLING HOLE
AS REQUIRED, 4 PL

0.893
REF

0.36
TYP

R0.063
4 PL

DART
D5134-041

GRAIN
DIRECTION

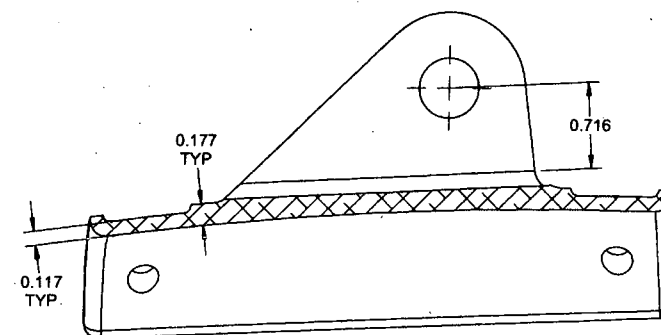
0.728
2 PL

4.671
REF

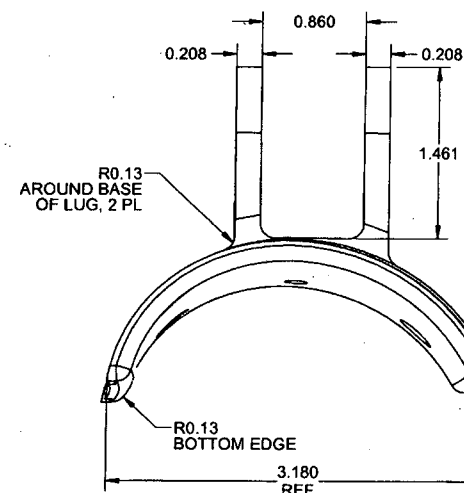
D5134-1 DAMPER SUPPORT, LH

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T6 (OR T651 / T6510 / T6511 / T652) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122 / 4123 / 4186 / 4187) OR
PER AMS-QQ-A-200/11, REF DART SPEC M7075T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-041" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.38 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-1-REVA.SLDPRT"
- 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES



SECTION A-A



RELEASED
2014-10-08

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5134	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
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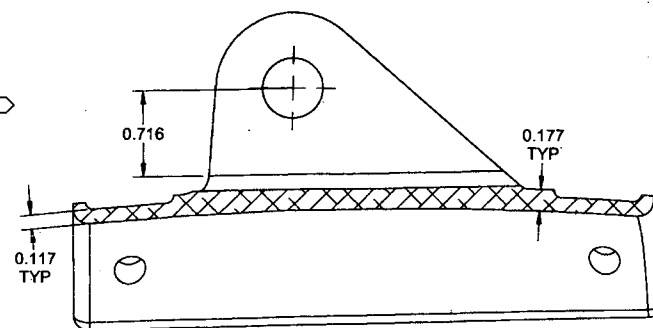
0.893
REF

B

A

Ø0.188 TOOLING HOLE
AS REQUIRED, 2PL

Ø0.257 TOOLING HOLE
AS REQUIRED, 4PL



SECTION B-B

0.36
TYP

R0.63

0.632

1.932

DART
D5134-042

R0.063
4 PL

GRAIN
DIRECTION

R0.25
THIS EDGE ONLY

Ø0.500^{+0.000}_{-0.001}
THRU

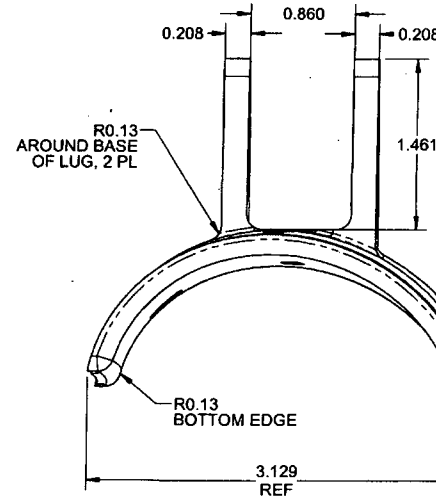
0.36
4 PL

0.100
2 PL

0.728
2 PL

4.671
REF

D5134-2 DAMPER SUPPORT, RH



RELEASED
2014-10-08
mp

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T6 (OR T651 / T6510 / T6511 / T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122 / 4123 / 4188 / 4187) OR
PER AMS-QQ-A-200/1, REF DART SPEC M7075T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-042" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.38 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-2-REVA.SLDPR" 7
 - 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5134	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	DAMPER SUPPORT ASSY	NTS
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